



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G08632-3G
Job Sheet 186959



Part No: RBW6405G08632-3G

Job Qty: 1 ea

Part Name: AW139 Tail Rotor Bushing Removal/Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G08632-3G Rev B IPP Rev.A 17.09.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off	DAS
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
90	Start up Operation	1 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Small Fab-4			30
110	Small Fab	1 pcs	12/14/18	12/14/18	0.00	0.33	Small Fab-8		M.L. DAS	9-89
120	QC	1 pcs	12/14/18	12/14/18	0.00	0.00	QC4			38
130	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1		M.L. 9-89	GADOP
140	QC21-SA	1 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DAS	

Part Op 90 - ***See engineering for placard sign off***
Descriptions:

21
9-89

DEC 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1200-E	Case	1 Ea (1 ea)	90-Start up Operation	5133055
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5021040
RBW6405G08632-3G-07 Bottom Tool Protector (Y-20, Black) use in case APP-1200-E		1 Ea (1 ea)	90-Start up Operation	5133057
RBW6405G08632-3G-09 Top Tool Protector (Y-20, Black) use in case APP-1200-E		1 Ea (1 ea)	90-Start up Operation	5133056
RBW6405G08632-3G-13 Inside Placard (Lasered)		1 Ea (1 ea)	90-Start up Operation	5137284
RBW6405G08732-3G	Tail Rotor Bushing Removal Tool	1 Ea (1 ea)	90-Start up Operation	5067413
RBW6405G08832-3G	Tail Rotor Bushing Install Tool	1 Ea (1 ea)	90-Start up Operation	5067536



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S136617



Part: RBW6405G08632-3G

Job No: 186959

Serial No/Batch: S136617

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 12/11/18

Allocations

Required	Inventory	Allocated
1	13	0
1	694	0
1	1	0
1	1	0
1	0 SP	0
1	1	0
1	1	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Part Specifications

Specifications could not be found.

Plex 11/23/18 9:26 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

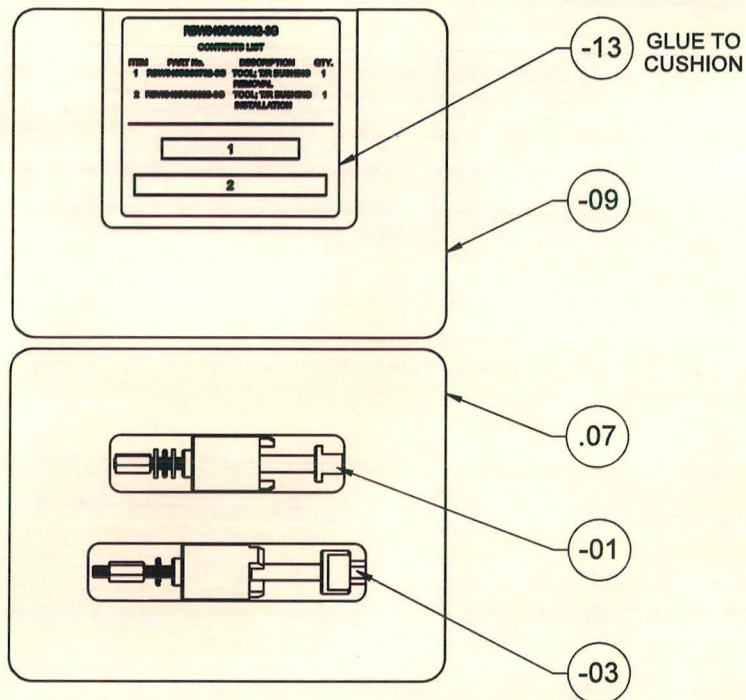
QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																				

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
A	SEPERATED OUT FROM KIT	3/14/11	JAG
B	-13 CH'D LETTERING COLOR WAS ALUMINUM IS WHITE. CH'D MATERIAL IN BOM WAS ALUMINUM IS PLASTIC. -9 CH'D MATERIAL WAS EPDM IS Y-20, BLACK.	3/12/13	BIM



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186959 MWS
18-11-23

B/O	PART #	QTY	DESCRIPTION	MATERIAL	B/O INFORMATION	Pg
	-01	1	T/R BUSHING REMOVAL TOOL		T/N RBW6405G08732-3G	1
	-03	1	T/R BUSHING INSTALL TOOL		T/N RBW6405G08832-3G	1
B/O	-05	1	HARD CASE	PLASTIC	PELICAN #200-1200-E	N/S
B/O	-07	1	BOTTOM TOOL PROTECTOR	Y-20; BLACK	3 x 7-1/4 x 9-1/2 I.R. SPECIALTIES	2
B/O	-09	1	TOP TOOL PROTECTOR	Y-20, BLACK	1-3/16 x 7-1/4 x 9-1/2 I.R. SPECIALTIES	3
B/O	-11	1	RB PLACARD, (on case top)	ALUMINUM	RB41009	N/S
B/O	-13	1	INSIDE PLACARD, (lasered)	PLASTIC	1/32 x 4-5/16 x 4-11/16	4

RED BARN MACHINE	
TITLE	
TAIL ROTOR BUSHING KIT	
DWG NO. RBW6405G08632-3G	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	METRIC .X ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 8-24-10
SHEET 1 of 4	

